

# Work Order ID 81427

March-14-12 8:29:17 AM

**\*81427\***

Page 1

Item ID: D3805-045  
Revision ID:  
Item Name: Wearplate Assembly Aft. Low Gear  
Start Date: 3/14/12 Start Qty: 8.00  
Required Date: 3/20/12 Req'd Qty: 8.00  
Reference:

Accept

**\*N9000040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

Cust Item ID:  
Customer:

**\*8\***  
**\*8\***

Approvals: Process Plan: W Date:  
QC: Date:

Tooling: Date:  
SPC (Y/N): Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3805	B
-------	---

0.00

**\*100\***

Large Fab

Large Fab

Memo

0.00

1- On D3806-5, fill cut outs with hardcoat welding rod as per dwg D3805  
2059 B Hardcoat Welding Rod  
BATCH#: M122030

2-weld D3806-5 to D3805-5 together as per dwg D3805  
304 S.S. Welding Rod  
BATCH#: M120013

3-Transfer drill holes in bar

\*\*\*CUT BAR TO FINISH SIZE AFTER WELDING HARD COAT\*\*\*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

Quality Control

Memo

0.00

(X10)

MAL

12/07/18

(16x)

12.7.18

DAS  
24  
8-8

# Work Order ID 81427

**\*81427\***

Page 2

March-14-12 8:29:17 AM

Item ID: D3805-045  
 Revision ID:  
 Item Name: Wearplate Assembly Aft, Low Gear  
 Start Date: 3/14/12 Start Qty: 8.00  
 Required Date: 3/20/12 Req'd Qty: 8.00  
 Reference:

Accept

**\*N9000040100\***

Setup Start **\*NS1\***  
 Stop **\*NS2\***

Cust Item ID:  
 Customer:

Approvals: Process Plan: Date: Tooling: Date:  
 QC: Date: SPC (Y/N): Date:

Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
130 <b>*130*</b> Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo START TIME: 11:15 OVEN TEMPERATURE: 320 °F FINISH TIME: 11:45	0.00 0.00							
140 <b>*140*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00							

DAS 16

17/07/12

20

10X

M-F  
12/07/19

M121279

10

12/07/19

**Work Order ID 81427**

March-14-12 8:29:17 AM

**\*81427\***

Page 3

Item ID: D3805-045

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 3/14/12 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 3/20/12 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

0.00

**\*150\***

Small Fab

Memo

0.00

Small Fab

1- Bond D3807-5 gasket to inner surface of wearplate using a thin layer of 3m  
1300/1300L scotch grip adhesive as per dwg  
BATCH: m/22 30610  $\phi$ Ae  
12-07-20

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

DAS  
16  
8-8

12/07/20

CIC

170

Identify as per dwg & Stock Location: FP-1

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

10  $\phi$  2P 12/07/23

**Work Order ID 81427**

March-14-12 8:29:17 AM

**\*81427\***

Page 4

Item ID: D3805-045

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearplate Assembly Aft. Low Gear

Start Date: 3/14/12 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 3/20/12 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/17/24  
MCS 12/18/23

# Picklist Print

March-14-12 8:29:17 AM

Page 1

Work Order ID: 81427

Parent Item: D3805-045

Parent Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 3/14/12

Required Date: 3/20/12

Start Qty: 8.00

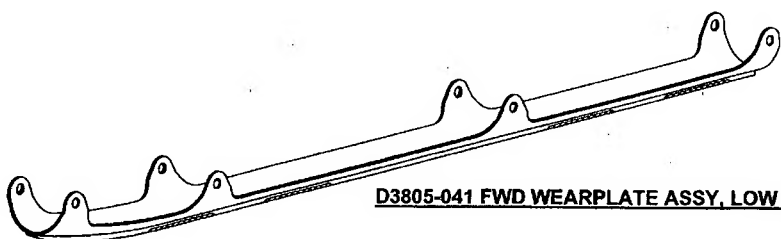
Required Qty: 8.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg  
DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

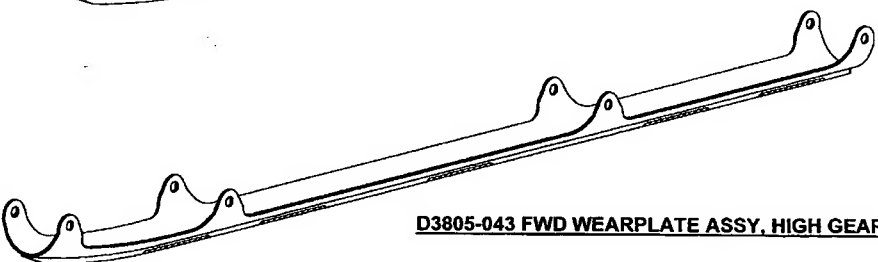
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-5 Plate		Manufactured	No			100	Each	38.0000	1	8			
B 79622 (X4)													
B 78128 (X2)													
B 80439 (X4)													
<del>B 8043</del>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		34			(X10)			MAL	12/07/18
				79568		20							
				79622		14							
				WA030		4							
				75676		2							
				78128		2							
D3806-5 Bar		Manufactured	No			100	Each	54.0000	1	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
B 80442 (X10)				WA		50			(X10)			MAL	12/07/18
				79570		30							
				80442		20							
				WA030		4							
				46781		2							
				75941		2							
D3807-5 Gasket		Manufactured	No			150	Each	75.0000	1	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		75						Ac	12.07.18
				74944		1							
				78132		3							
				79572		37			(10)				
				79626		34							

8 7 6 5 4

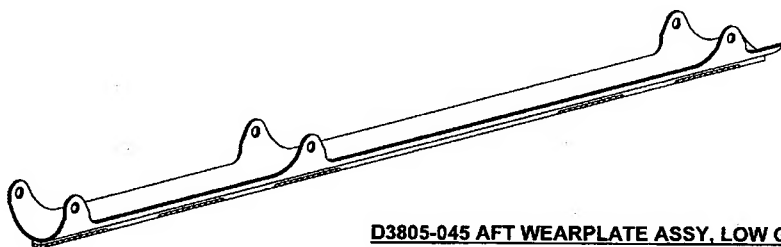
3 2 1



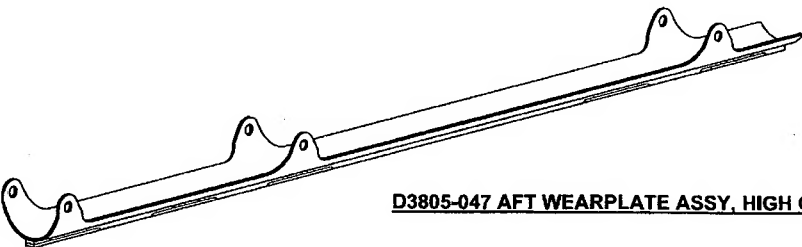
**D3805-041 FWD WEARPLATE ASSY, LOW GEAR**



**D3805-043 FWD WEARPLATE ASSY, HIGH GEAR**



**D3805-045 AFT WEARPLATE ASSY, LOW GEAR**



**D3805-047 AFT WEARPLATE ASSY, HIGH GEAR**

8 7 6 5 4

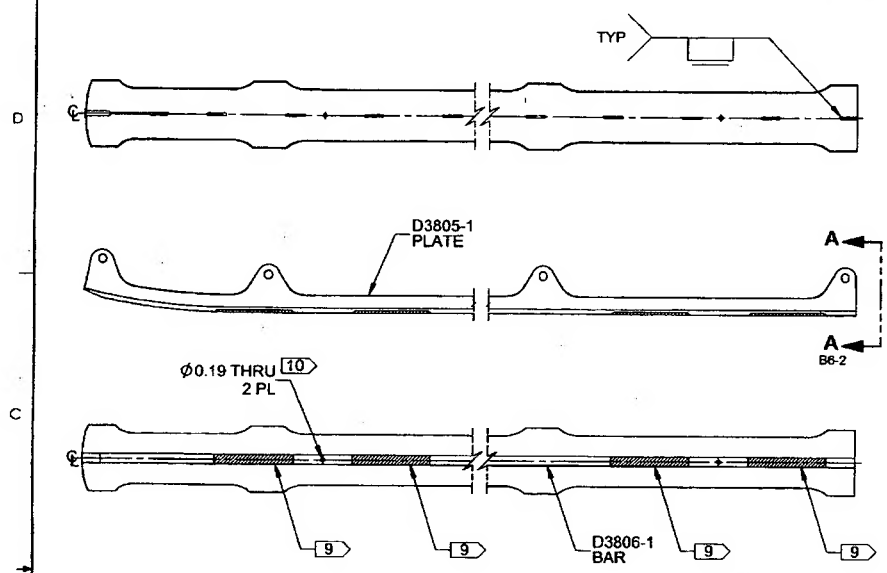
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

*W/081427*

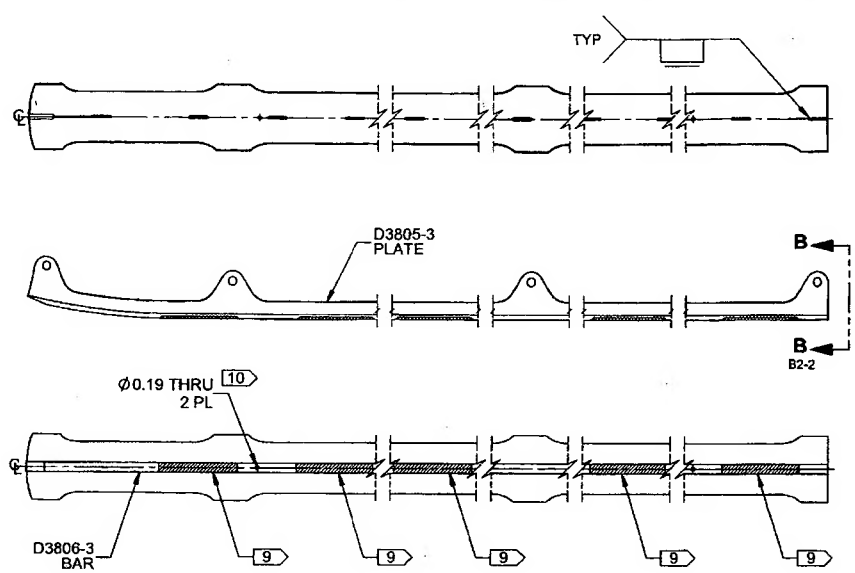
**RELEASED**  
2011-10-03

B	REVISED D3805-1F/3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PART 11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3		MB	11.09.16
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE USA, INC.			
DRAWN	KENT, WA			
CHECKED	DRAWING NO. D3805		REV. B	
MFG. APPR.	TITLE WEARPLATE ASSY		SHEET 1 OF 8	
APPROVED	DATE 11.09.16		SCALE NTS	
DE APPR.	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			

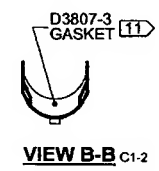
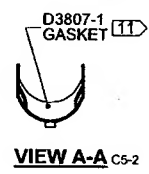
8 7 6 5 4 3 2 1



**D3805-041 FWD WEARPLATE ASSY, LOW GEAR**



**D3805-043 FWD WEARPLATE ASSY, HIGH GEAR**



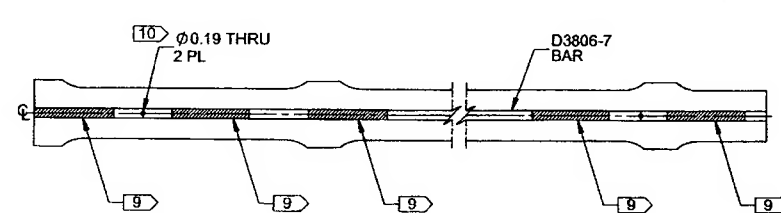
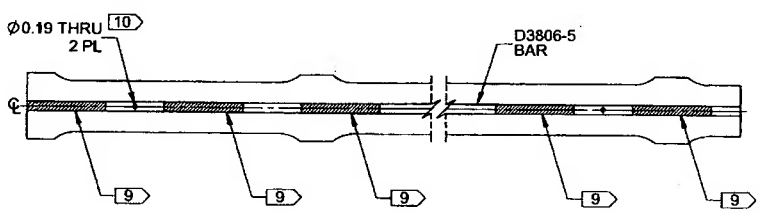
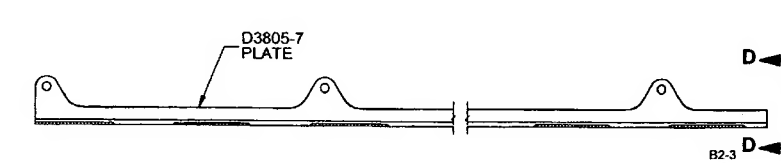
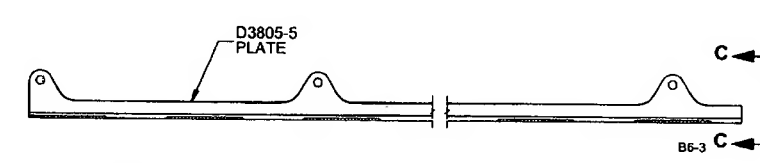
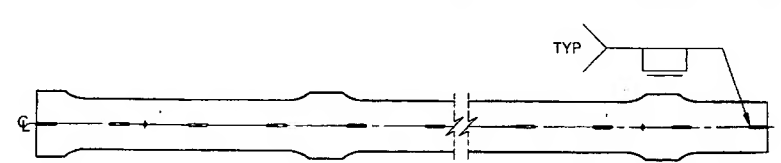
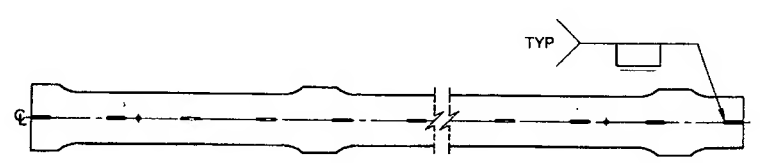
**RELEASED**  
2011-10-03

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
  - 8) WELDING: PER QSI 004
  - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
  - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
  - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.09.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

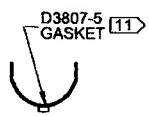
8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

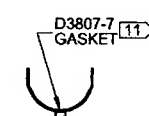


**D3805-045 AFT WEARPLATE ASSY.**

**D3805-047 AFT WEARPLATE ASSY.**



**VIEW C-C C5-3**



**VIEW D-D C1-3**

**RELEASED**  
2011-10-03

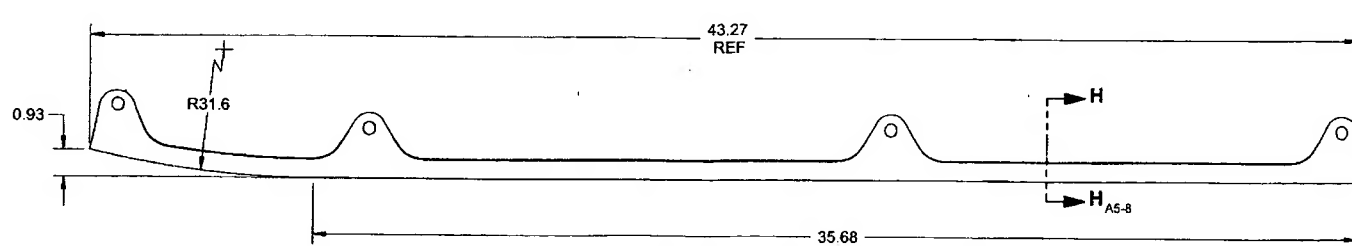
- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
  - 8) WELDING: PER QSI 004
  - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
  - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
  - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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MFG. APPR.		D3805	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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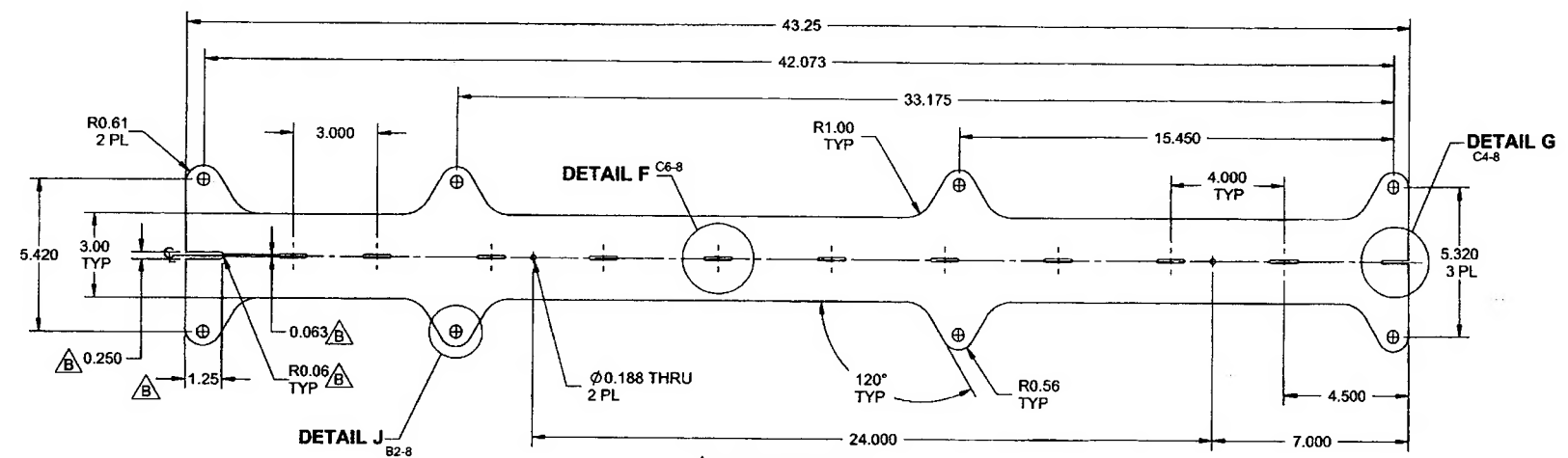
8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



**D3805-1 PLATE**  
(MAKE FROM D3805-1F)



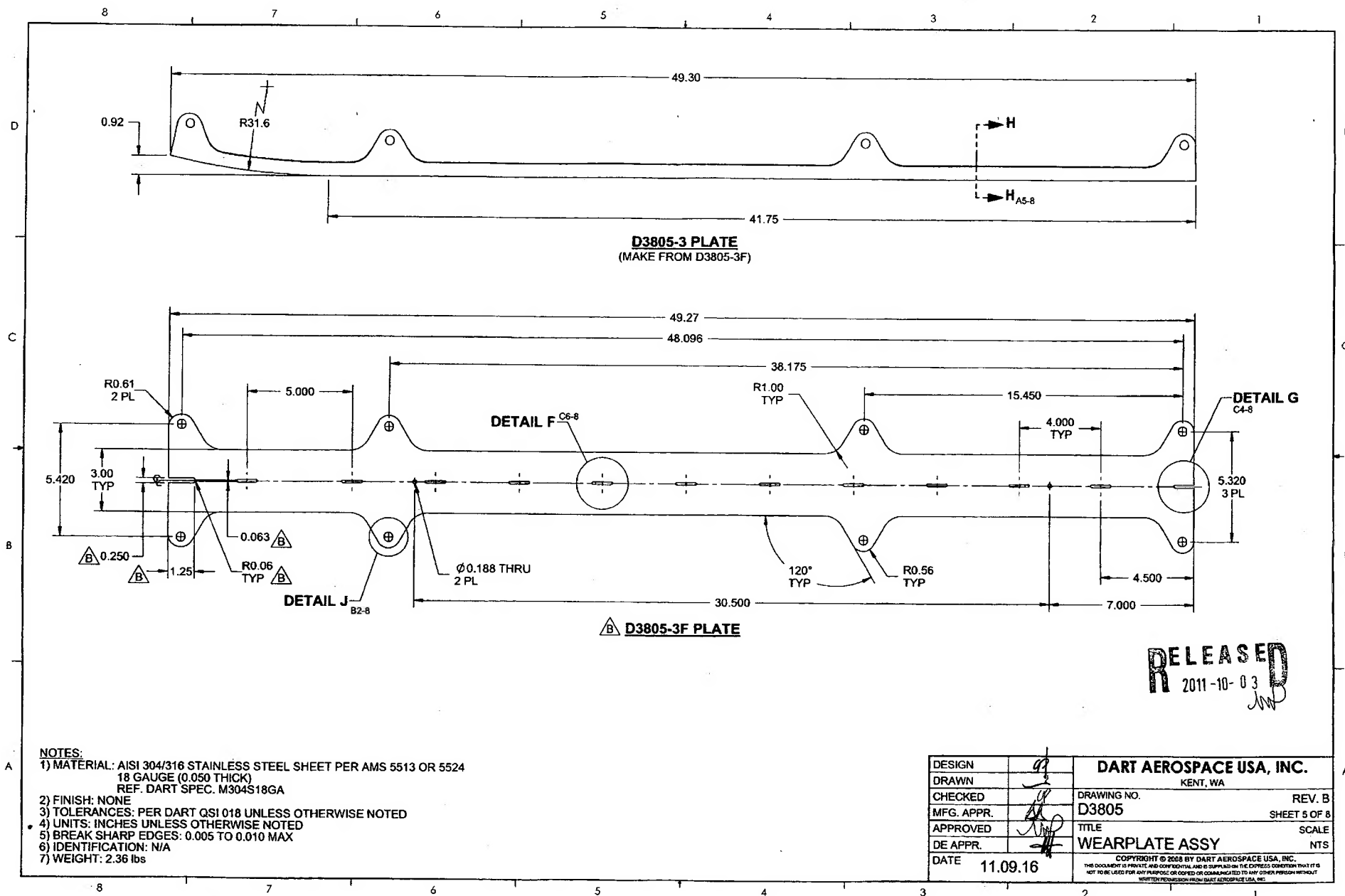
**D3805-1F PLATE**

**RELEASED**  
2011-10-03

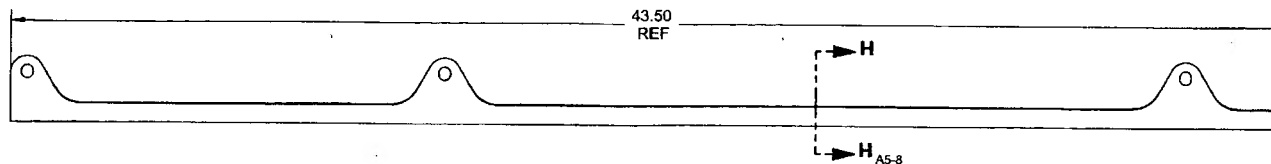
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 2.11 lbs

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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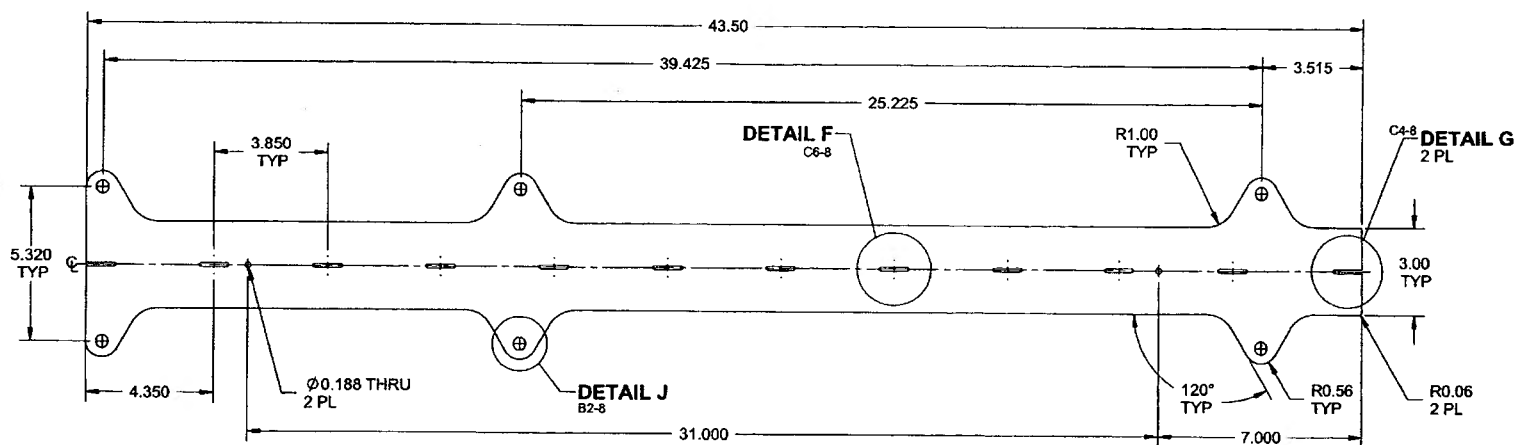
8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



**D3805-5 PLATE**  
(MAKE FROM D3805-5F)



**D3805-5F PLATE**

**RELEASED**  
2011-10-03

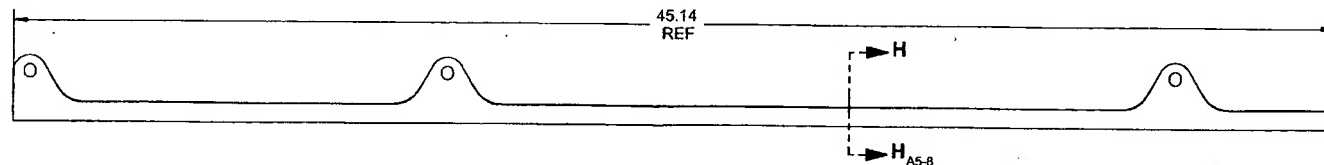
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

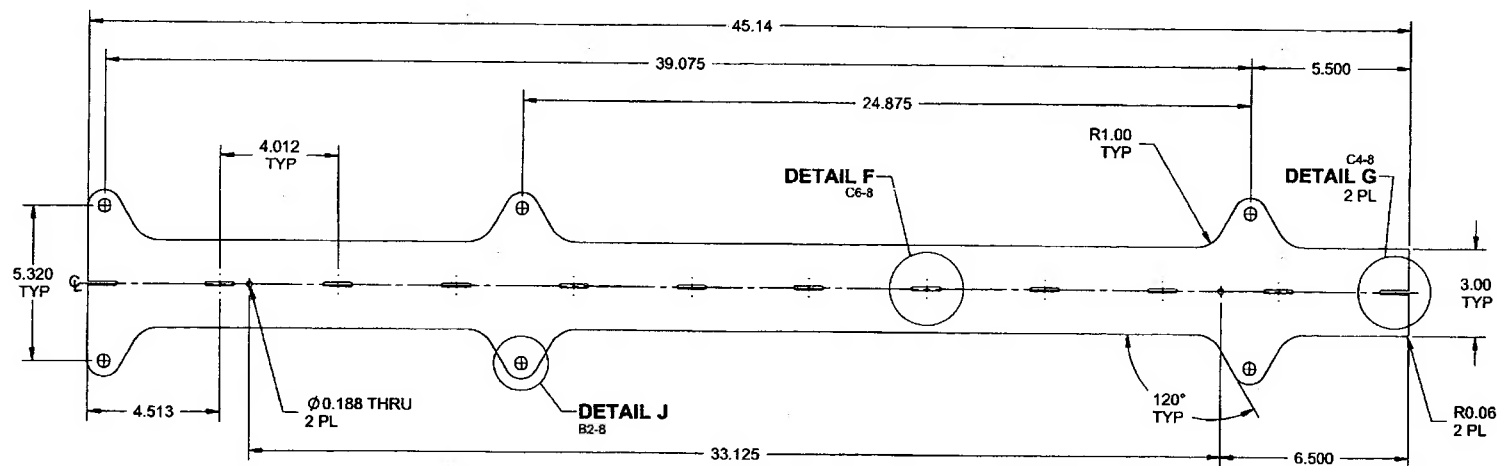
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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3805</b>	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		<b>WEARPLATE ASSY</b>	NTS
DATE	<b>11.09.16</b>	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



**D3805-7 PLATE**  
(MAKE FROM D3805-7F)



**D3805-7F PLATE**

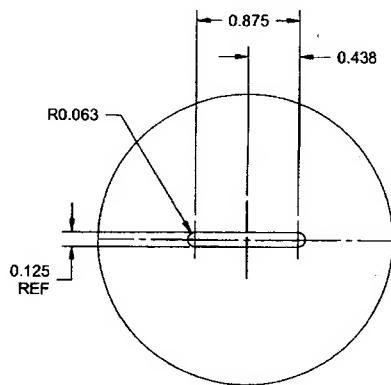
**RELEASED**  
2011-10-03

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

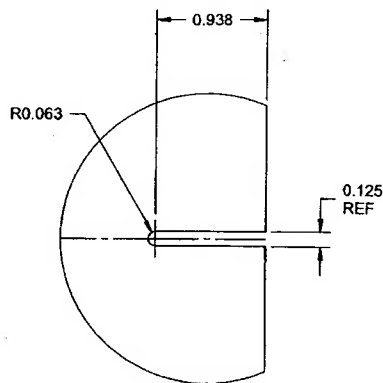
DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. <b>D3805</b>	REV. B
MFG. APPR.			SHEET 7 OF 8
APPROVED		TITLE <b>WEARPLATE ASSY</b>	SCALE
DE APPR.			NTS
DATE	11.09.16	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



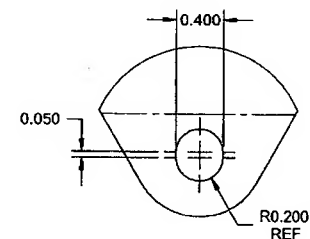
**DETAIL F**  
SLOT DETAIL TYP  
SCALE 4X

C5-4  
C5-5  
C4-6  
C4-7



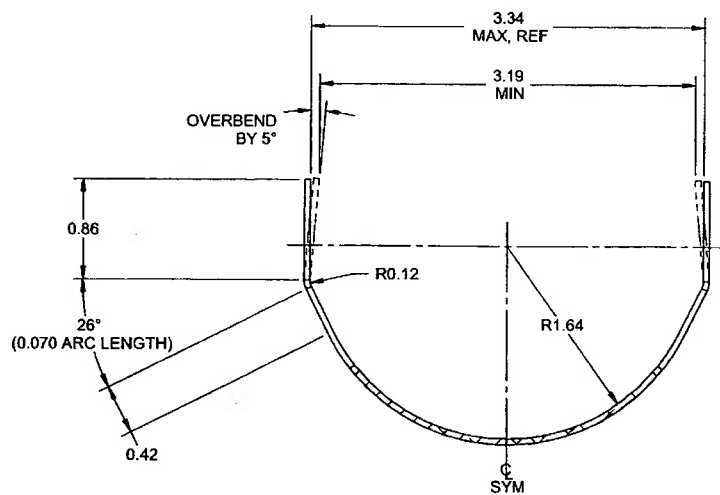
**DETAIL G**  
SLOT DETAIL TYP  
SCALE 4X

C1-4  
C1-5  
C1-6  
C2-7



**DETAIL J**  
SCALE 4X

B6-4  
B7-5  
B5-6  
B5-7



**SECTION H-H**  
SCALE 4X

D3-4  
D3-5  
D3-6  
D3-7

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